



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4297-1
Job Sheet 169991



Part No: D4297-1

Job Qty: 10 ea

Part Name: Bearpaw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/5/18

Job Tracking No:

Due Date: 1/15/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 11-01-05 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		1/12/18	0.00	0.00	Start Up Waterjet		on 18/01/09
120	Waterjet	10 pcs		1/12/18	0.00	2.33	Waterjet1		on 18/01/09
130	CNC Vertical Machining	10 pcs		1/15/18	0.00	14.74	HAAS1-4		SC 18/01/22
140	QC	10 pcs		1/15/18	0.00	0.00	QC2 Machining-2		SC 18/01/22
150	QC	10 pcs		1/15/18	0.00	0.00	QC8 Machining-2		SK 18/01/22
151	Packaging	10 pcs		1/15/18	0.00	0.00	Packaging3	ST470A	AT 18/01/22
190	QC21-SA	10 Ea		1/15/18	0.00	0.00	QC21		

Part Op 120 - Cut Blank as per D2432 File

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA028 and Dwg DWG

REV: _____ FOLIO REV: _____ 3-Deburr

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MUHMWB10	37	990	0	0

Part Specifications

Specifications could not be found.

Plex 1/5/18 11:35 AM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL : 1 613 632 - 5200 Email: sales@dartaero.com www.dartaerospace.com					
Description Work Order Deviation 									
Root Cause <table style="width:100%;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%;"> <tr> <td style="width:50%;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:50%;"> Tempe ☐ Set-up ☐ BOM/f ☐ Broker ☐ Inspect ☐ Contan ☐ Counte ☐ Cut To ☐ Instruc ☐ Drill Holes ☐ </td> </tr> </table>		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Tempe ☐ Set-up ☐ BOM/f ☐ Broker ☐ Inspect ☐ Contan ☐ Counte ☐ Cut To ☐ Instruc ☐ Drill Holes ☐	 S030530 DART AEROSPACE Bearpaw D4297 - 1 Start up Operation PART NO: Revision: Operation: Change No:	
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐								
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OTHER : _____				Mfg Date: 01/09/18 Job No: 169991 B (QSI042) Approval _____ Completed By _____ d hand / Supervisor proval Verification _____ / QA Coordinator Approval _____ sitioned Wrong tside Dimensions er/Under tolerance t Incorrect t Lost/Missing t Moved ewing ish read Turning Sequence					

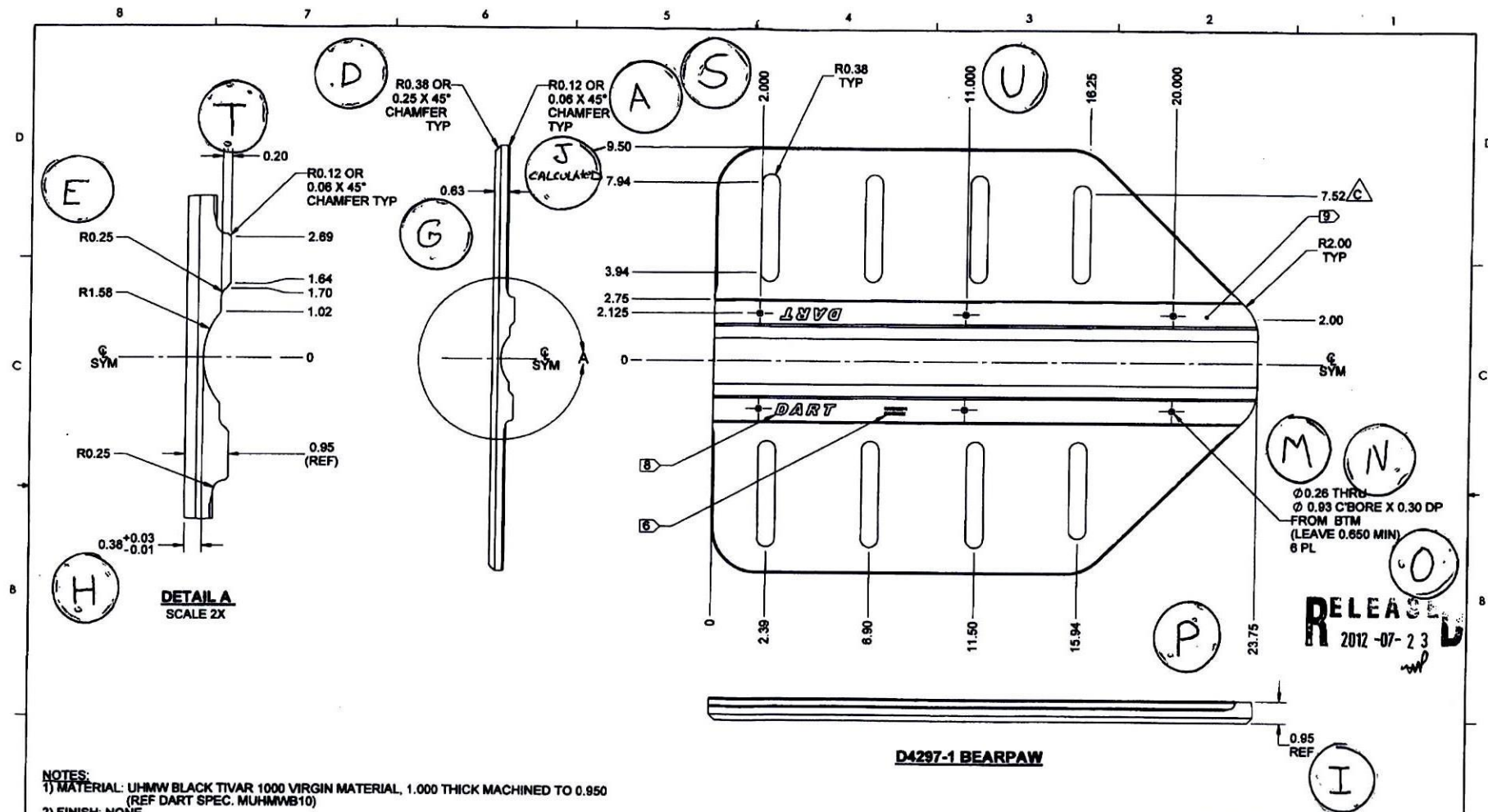
DART AEROSPACE LTD		Work Order: 169999
Description: Bearpaw		Part Number: D4297-1
Inspection Dwg: D4297 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063 x 45°	✓		Ver	
D	0.25 x 45°	+/-0.030	0.25 x 45°	✓		TAPE	
E	R0.250	+/-0.030	0.250	✓		R.G.	
G	0.63	+/-0.030	0.63	✓		Ver	
H	0.38	+0.030/-0.010	0.38	✓		Ver	
I	0.950	+/-0.030	0.950	✓		Ver	
J	19.000	+/-0.030	19.000	✓		TAPE	
M	Ø0.260	+0.005/-0.000	Ø0.26			G.P	
N	Ø0.93	+/-0.030	0.93			Ver	
O	0.30	+0.030/-0.000	0.312			D.G.	
P	23.750	+/-0.030	23.750			TAPE	
S	2.000	+/-0.030	2.000	✓		Ver	
T	0.20	+/-0.030	0.20	✓		D.G.	
U	11.000	+/-0.010	11.000	✓		Ver	

Measured by: S.C.	Audited by: [Signature]	Preliminary Approval:
Date: 18/01/21	Date: 18/01/22	Date:

Rev	Date	Change	Revised by	Approved
A	11.01.20	New Issue P/O D350-578-013	KJ	
B	12.02.01	Dwg Rev updated	KJ	
C	12.07.31	Dwg Rev updated	KJ	
D	15.02.09	Dimensions revised	KJ	[Signature]



NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.000 THICK MACHINED TO 0.950 (REF DART SPEC. MUHMWB10)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER "D4297-1" AND BATCH NUMBER "BXXXXX" IN ACCORDANCE WITH QSI 044 METHOD 8.3
- 7) WEIGHT: 8.18 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.012
- 9) APPLY 0.06 x 45° CHAMFER TO ALL EDGES ON SIDE SHOWN UNLESS OTHERWISE INDICATED
- 10) PROFILE PER DRAWING FILE "D4297-1-REVC.STP"

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	9/	D4297	SHEET 2 OF 3
APPROVED	10	TITLE	SCALE
DE APPR.	10	BEARPAW	NTS
DATE	12.07.13	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	